

Date: Wednesday, 1/23/2008 11:31:18 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|---------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DRIVE SHAFT TUNNEL |
| Job Number | : 36910 | | |
| Estimate Number | : 13044 | | |
| P.O. Number | : | Part Number | : D3648041 |
| This issue | : 1/23/2008 S.O. No. : | Drawing Number | : D3648 REV.B U/R |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : SMALL /MED FAB | Drawing Revision | : B U/R |
| Previous Run | : 35973 | Material | : |
| Written By | : | Due Date | : 2/29/2008 Qty: Um: Each |
| Checked & Approved By | : | | |
| Comment | : Est Rev:A New Issue 07-10-03 EC verified by: DD Est Rev:B Ecn 1113P 08-01-22 DD | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|-----------------------|
| 1.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

| | | |
|-----|----------|-------------------------------|
| 2.0 | D3649041 | TUNNEL ASSEMBLY, BOTTOM PANEL |
|-----|----------|-------------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 TUNNEL ASSEMBLY, BOTTOM PANEL
 batch: ~~B36911~~ B 36911

| | | |
|-----|----------|------------------------------|
| 3.0 | D3650041 | WELDMENT ASSEMBLY, TOP PANEL |
|-----|----------|------------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 WELDMENT ASSEMBLY, TOP PANEL
 batch: ~~B36912~~ B 36912

| | | |
|-----|----------|-------------------|
| 4.0 | D3651041 | AFT BASE ASSEMBLY |
|-----|----------|-------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 AFT BASE ASSEMBLY
 batch: ~~B36913~~ B 36913

| | | |
|-----|--------|------|
| 5.0 | AN3C3A | Bolt |
|-----|--------|------|



Comment: Qty.: 40.0000 Each(s)/Unit Total : 80.0000 Each(s)
 Bolt
 batch: ~~M106993~~ M106993

Handwritten signature and date: 08-03-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 21/03/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRIVE SHAFT TUNNEL

Job Number: 36910

Part Number: D3648041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 40.0000 EACH(s)/Unit Total : 80.0000 EACH(s)

WASHER

batch: 1106302

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3648

2- Seal mating surface and all gaps as per dwg D3648 with

Proseal 700 fire wall sealant

batch: 1106294

08.03.13 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

06.03.13

08.03.14 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: PPD 38103

08.03.14

(1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.03.18

Job Completion



08.03.14

POSITIVE RECALL

EFFECTIVE 06.03.13 AUTH U

RELEASED 18 DATE 06.03.13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

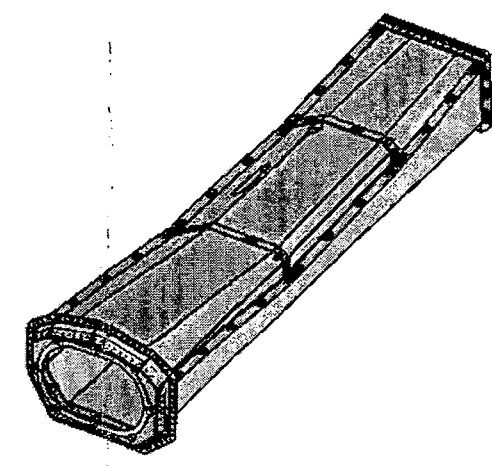
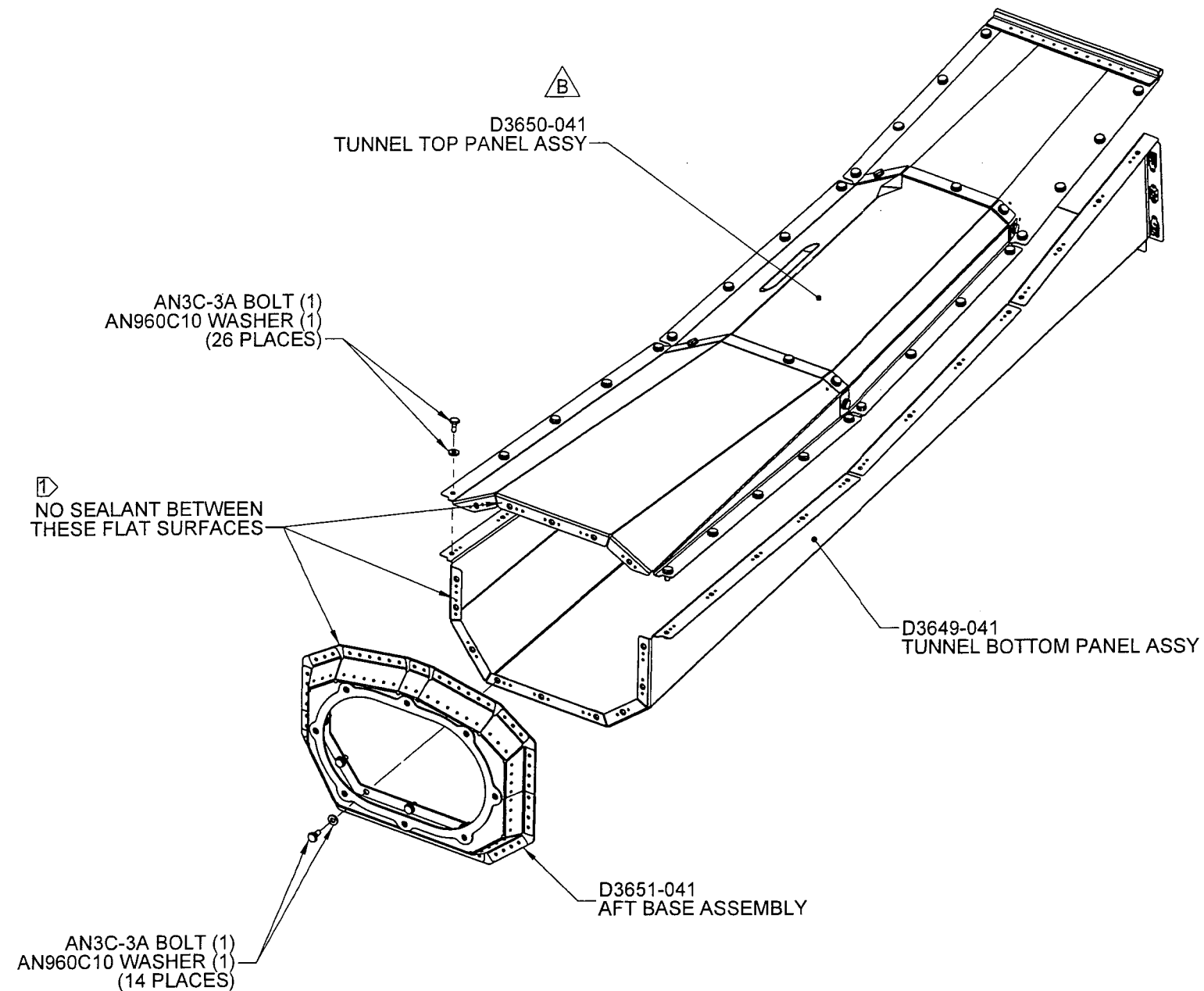
A

D

C

B

A



D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

- NOTES:**
1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
7) TORQUE FASTENERS TO 15-25 in-lb
8) WEIGHT: 9.2 lbs

PART LIST

| QTY -041 | PART NUMBER | DESCRIPTION |
|-------------|-------------|------------------------------|
| X | D3648-041 | DRIVE SHAFT TUNNEL ASSEMBLY |
| 1 | D3649-041 | TUNNEL BOTTOM PANEL ASSEMBLY |
| 1 | D3650-041 | TUNNEL TOP PANEL ASSEMBLY |
| 1 | D3651-041 | AFT BASE ASSEMBLY |
| 40 | AN3C-3A | BOLT |
| 40 | AN960C10 | WASHER |

| | | | |
|------------|-------------------------------|--|--------------|
| B | UPDATE WITH REVISED D3650-041 | RF | 08.01.07 |
| A | NEW ISSUE | RF | 07.11.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | VE | DRAWING NO. | REV. B |
| MFG. APPR. | DA | D3648 | SHEET 1 OF 1 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | JH | DRIVE SHAFT TUNNEL ASSY | 1:6 |
| DATE | 08.01.07 | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |